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ShopBot Part Wizard
  • can draw simple shapes in wizard instead of importing Rhino vector.
    • be sure to save toolpaths if drawing in wizard
      • saved as dxf files
  • <u>preview and get acquainted with toolpaths</u>
  • be super careful, careless keystrokes can trigger shortcuts
  • material Z-zero
    • set with zero plate function [**C**][2]
      • can be nudged later on if piece is not fully cut.
    • couple thousandths over top of block.

CNC Bed
  • can get away w/ 18"x18" sheets min.
  • use jigs for tasks that require replication.
  • mount material on corresponding(by size) zone(s)
    • make sure it's square, especially if tolerances are high
    • open valve(s) for zone(s)
  • use vacuum with cone attachment
    • turn on and tape if needed

Cutter
  • can accomplish smaller and larger cuts depending upon cutter.
    • different chucks for S and L cutters
    • fairly sharp, handle w/ care
  • always be super cautious of moving cutter in any direction, the stepper motors can generate electricity atd damage the system if moved manually.
  • when setting Z-zero remember to remove zero plate and clamp from cutter
  • use cutter blades parallel to material edges to aid in (X,Y) zeroing
  • insert cutter w/ a couple mm of stock outside of chuck

Setup, things to take note of and triple check.
- ✓ correct file
- ✓ 2D profile - default
- ✓ area clearance - raster
- ✓ machining - exact
- ✓ tool groups
- ✓ zero (X,Y,Z)
- ✓ speed of passes
- ✓ choice of cutter
  - • tool database
- ✓ rotation of cutter
- ✓ cut direction
  - •
- ✓ speed of spindle
- ✓ cutting inside / outside of toolpath
- ✓ plunge speed